

29/03

Date: Thursday, 3/15/2007 3:10:51 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD AIRFLOW HEATER SYSTEM
Job Number	: 31242		
Estimate Number	: 12345		
P.O. Number	: N/A	Part Number	: D206746011
This Issue	: 3/15/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: N/A
Previous Run	: 28505	Material	: N/A
Written By	:	Due Date	: 3/28/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.15</u>		
Comment	: est rev.A 06.03.23 new issue EC est rev.B 06.04.26 updated pick list EC Est Rev.C 06-05-24 Per Rev A JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-746-011 CHG001

KS 07.03.15 (1)

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	31242A	REAR OVERHEAD PASSENGER MODIFICATION KIT
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Comment: Sub-Component REAR OVERHEAD PASSENGER MODIFICATION KIT

D206-746-041 B 3/24/20

6/3/30 (1)

4.0	31242B	REAR OVERHEAD PASSENGER MODIFICATION KIT
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Comment: Sub-Component REAR OVERHEAD PASSENGER MODIFICATION KIT

D206-746-043

B3/24/20

6/3/30 (1)

5.0	D3467041	SHROUD ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHROUD ASSEMBLY

Batch: B28536 011 ✓

X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 31242

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D34681

SEAL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

Batch: B31258 ✓

7.0

D34683

LARGE SEAL STRIP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LARGE SEAL STRIP

Batch: B26952 ✓

8.0

D34685

SEAL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

Batch: B31256 ✓

9.0

D3469041

SHUT-OFF VALVE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHUT-OFF VALVE ASS'Y

Batch: B25038 ✓

10.0

D34693

UPPER PLATE BENDING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

UPPER PLATE BENDING DETAIL

11.0

D34715

STIFFENER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

Batch: B28542 ✓

12.0

D3475041

DUMP OUTLET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP OUTLET

Batch: B26616 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31242

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34755

SCREEN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screen

Batch: B28845 ✓

14.0

D34757

scoop outlet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

scoop outlet

Batch: B30470 ✓

15.0

D34759

OUTLET GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

OUTLET GASKET

Batch: B28546 ✓

16.0

D3478041

AIR INLET ADAPTER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET ADAPTER

Batch: B28520 ✓

17.0

D34785

SCREEN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SCREEN

Batch: B28734 ✓

18.0

D34787

INLET GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET GASKET

Batch: B27457 ✓

19.0

D34789

INLET SCOOP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET SCOOP

Batch: B27542 ✓

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W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D3481041

Shut off valve bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Shut off valve bracket
Batch: B28532 ✓

21.0

D34821

INLET INSULATION SOCK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
INLET INSULATION SOCK
Batch: B26963 ✓

22.0

D34823

OUTLET INSULATION SOCK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
OUTLET INSULATION SOCK
Batch: B26387 ✓

23.0

D34825

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
HOSE INSULATION
Batch: B26967 ✓

24.0

D34827

HOSE INSULATION



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
HOSE INSULATION
Batch: B26387 ✓ ✓

25.0

D34829

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
HOSE INSULATION
Batch: B26387 ✓ ✓

26.0

D348211

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
HOSE INSULATION
Batch: B26387 ✓ ✓

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W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D348213

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: B31262 ✓

28.0

D34831

DUMP VALVE PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP VALVE PLACARD

Batch: B31263 ✓

29.0

D34833

SHUT-OFF VALVE PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHUT-OFF VALVE PLACARD

Batch: B26377 ✓

30.0

D34835

warning label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP VALVE PLACARD

Batch: B26471 ✓

31.0

31903

BLUE TERMINAL AMP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BLUE TERMINAL AMP

Batch: M101053 ✓

32.0

AN33A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Batch: M103641 ✓

33.0

AN35

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

BOLT

Batch: M106771 ✓

Dart Aerospace Ltd

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Job Number: 31242

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN9604L

washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
washer M101389 ✓

35.0

AN9608

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
WASHER (A/R)
Batch: M19356 QTY 12 ✓

36.0

AN96010L

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Washer M101340 ✓ ✓

37.0

CR322343

Cherry Rivet



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Cherry Rivet
Batch: A12706 ✓ ✓

38.0

DCS549

TURN-TO-LOCK CONTROL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PUSH/PULL CONTROL
Batch: M102211 ✓ ✓

39.0

M227591169

16GA ELECTRICAL WIRE, 120" LONG



Comment: Qty.: 10.0000 ft(s)/Unit Total : 10.0000 ft(s)
16GA ELECTRICAL WIRE, 120" LONG
Batch: M101053 ✓

40.0

MS21083N08

NUT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Qty (A/R) NUT
Batch: M100993 M100771 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 31242

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS21919DG3

CLAMP



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty (A/R) CLAMP

Batch: M100798 ✓

42.0

MS21919DG44

CLAMP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CLAMP

Batch: M100771 ✓ ✓

43.0

MS21919DG48

CLAMP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP

Batch: M100998 ✓ ✓

44.0

MS24166D1

RELAY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RELAY

Batch: M102129 ✓ ✓

45.0

MS2524475

CIRCUIT BREAKER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CIRCUIT BREAKER

Batch: M101467 ✓ ✓

46.0

MS2524415

BREAKER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BREAKER

Batch: M101369 ✓ ✓

47.0

MS270390816

SCREW PAN HD



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty 10 (A/R) SCREW PAN HD

Batch: M102171 ✓ ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 31242

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

MS3505822

SWITCH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH

Batch: M102171 ✓ ✓

49.0

NAS43DD316N

SPACER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty 9 (A/R) SPACER

Batch: M10297 ✓

50.0

NAS43DD348FC

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: M117179 101296 ✓ ✓

51.0

NAS679A3

NUT SELF LOCK



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

NUT SELF LOCK

Batch: M100651 ✓ ✓

52.0

QS20044S

CLAMP



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLAMP

Batch: M103338 ✓ ✓

53.0

QS20056S

CLAMP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

CLAMP

Batch: M100863 3X ✓ ✓ M103947 5X ✓ 4/03/21 SQ

54.0

SCEET11

SCEET



Comment: Qty.: 12.0000 f(s)/Unit Total : 12.0000 f(s)

SCEET

Batch: M102627 M102 M102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 31242

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

SCEET12

HOSE 3" DIAMETER



Comment: Qty.: 11.0000 f(s)/Unit Total : 11.0000 f(s)

HOSE 3" DIAMETER

Batch: m. 1568 x 6 FT

m 1653 x 6 FT

01/03/20 SG

56.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

02/3/20

02/03/30 ①

57.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP

02/3/

02/03/30 ① REV. B

58.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

02/03/30 ①

Job Completion



U 02-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Thursday, 3/15/2007 3:11:32 PM
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Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REAR OVERHEAD PASSENGER MODIFICATION KIT
Job Number	: 31242A		
Estimate Number	: 12344		
P.O. Number	: N/A	Part Number	: D206746041
This Issue	: 3/15/2007 S.O. No. : N/A	Drawing Number	: UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: N/A
Previous Run	: 28505A	Material	: N/A
Written By	:	Due Date	: 3/28/2007
Checked & Approved By	: <u>07.03.15</u>	Qty:	1 Um: Each
Comment	est rev A 06.03.22 New Issue EC est rev B 06.04.26 Updated picklist EC Est Rev:C 06-05-24 As Per Rev A JLM		

REMOVE FROM
UNDER REVIEW 07.03.15

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-746-041 CHG 001

N/A

2.0	D3472041	CABIN HEAT OUTLET DEFLECTOR
-----	----------	-----------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	batch
2	D3472-041	Cabin Heat outlet	<u>B31834</u> ✓

3.0	D34725	FLAT DOUBLER
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	batch
2	D3472-5	Flat doubler	<u>B31537</u> ✓ ✓

4.0	D3479041	INLET ADAPTER
-----	----------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	batch
2	D3479-041	Inlet adapter	<u>B31269</u> ✓ ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31242A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3480041

Eyeball Inlet adapter



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3480-041	eyeball inlet adapter

batch

1328528 ✓

6.0

D3480043

Eyeball adapter



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3480-043	Eyeball adapter

batch

131269 ✓ ✓

7.0

D34807

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3480-7	Gasket

batch

131261 ✓ ✓

8.0

99770094

FRESH AIR VENT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	9977009-4	Bell eyeball

batch

1100158 ✓ ✓

9.0

AN34A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
8	AN3-4A	Bolt

batch

1103641 ✓ ✓

W/O:		WORK ORDER CHANGES					
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Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 31242A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN96010L

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description
16 AN960-10L Washer

batch

M101340 ✓ ✓

11.0

CR224842

RIVET



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description
24 CR2248-4-2 Rivet

batch

M101334 ✓ ✓

12.0

HA000611

CARBON MONOXIDE INDICATOR



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON MONOXIDE INDICATOR

M101042 ✓ ✓

13.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description
8 MS27039-1-10 Screw

batch

M18836 ✓ ✓

14.0

NAS1738B42

Blind Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description
12 NAS1738B4-2 Rivet

batch

M19347 ✓ ✓

15.0

NAS679A3

NUT SELF LOCK



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description

batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/03/30
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 31242A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8 NAS679A3 Lock nut

M10065/ ✓

16.0

TY527M

TYRAPS



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

batch

4 TY-527M Ty raps

M10L141 ✓

07/03/20 SP

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Pc 7/3/30 (1) 070763130 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-041

Location:

PPP Rev:

PPP B 31242 Pc 7/3/30

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

① 070763130

Job Completion



U 07-03-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/15/2007 3:11:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ~~REAR OVERHEAD PASSENGER MODIFICATION KIT~~
 Job Number : 31242B **BLOWER MOTOR ASSEMBLY**
 Estimate Number : 12509
 P.O. Number : *N/A* Part Number : D206746043
 This Issue : 3/15/2007 S.O. No. : *N/A* Drawing Number : DSI9341
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : *AB*
 Previous Run : 28505B Material : *N/A*
 Written By : Due Date : 3/28/2007 Qty: 1 Um: Each
 Checked & Approved By : *07.03.15*
 Comment : est rev A 06.08.21 New Issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3471041 BLOWER MOTOR SUPPORT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 BLOWER MOTOR SUPPORT
 Batch: *B 28541*

2.0 D3473041 BLOWER INLET ADAPTER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 BLOWER INLET ADAPTER
 Batch: *B 28543*

3.0 D3476041 blower motor adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 blower motor adapter
 Batch: *B 28547*

4.0 D3477041 Blower Motor Inlet Adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Blower Motor Inlet Adapter
 Batch: *B 31258*

5.0 D35851 SET SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 SET SCREW *B 31384*

MF 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 20 Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/15/2007 3:11:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 31242B

Part Number: D206746043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

26D71

Blower Motor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

JANITROL BLOWER MOTOR ASSEMBLY

Batch: M103978 -

7.0

AN33A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: M103641 -

8.0

AN96010

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch: M5519 -

MF 07-03-30

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg DSI 9341

locking wire M12189

Add locktite 26221 to fan set screw batch: M12189 M102855 MF 07-03-30

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/30 ①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-043

Location: NA

PPP Rev: NA

PPP D206-746-011 B31242

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 07/03/30 ①

Job Completion



LL 5K-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9341	REV. B SHEET 1 OF 2
DATE 07.01.02		TITLE BLOWER MOTOR ASSEMBLY SCALE NTS	
REV	DATE	DESCRIPTION	
A	06.08.09	NEW ISSUE	
B	07.01.02	ADD D3585-1 & DETAIL B	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV.A

REF. CANADIAN STC: SH05-45 ISSUE 1

FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

Qty -011	Qty -041	Qty - 043	Part Number	Description
X			D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X		D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		X	D206-746-043	BLOWER MOTOR ASSEMBLY
		1	D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
		1	D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
		1	D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
		1	D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
<i>B</i>		2	D3585-1	SET SCREW
<i>B</i>		A/R	26221	LOCTITE 226 THREADLOCKER
		1	26D71	BLOWER MOTOR (26D71-1)
		6	AN3-3A	BOLT
		6	AN960-10	WASHER
		3	MS27039-08-04	MACHINE SCREW
		3	MS35333-38	LOCK WASHER
<i>B</i>		A/R	MS20995-025E	LOCK WIRE

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

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NO. 31242B

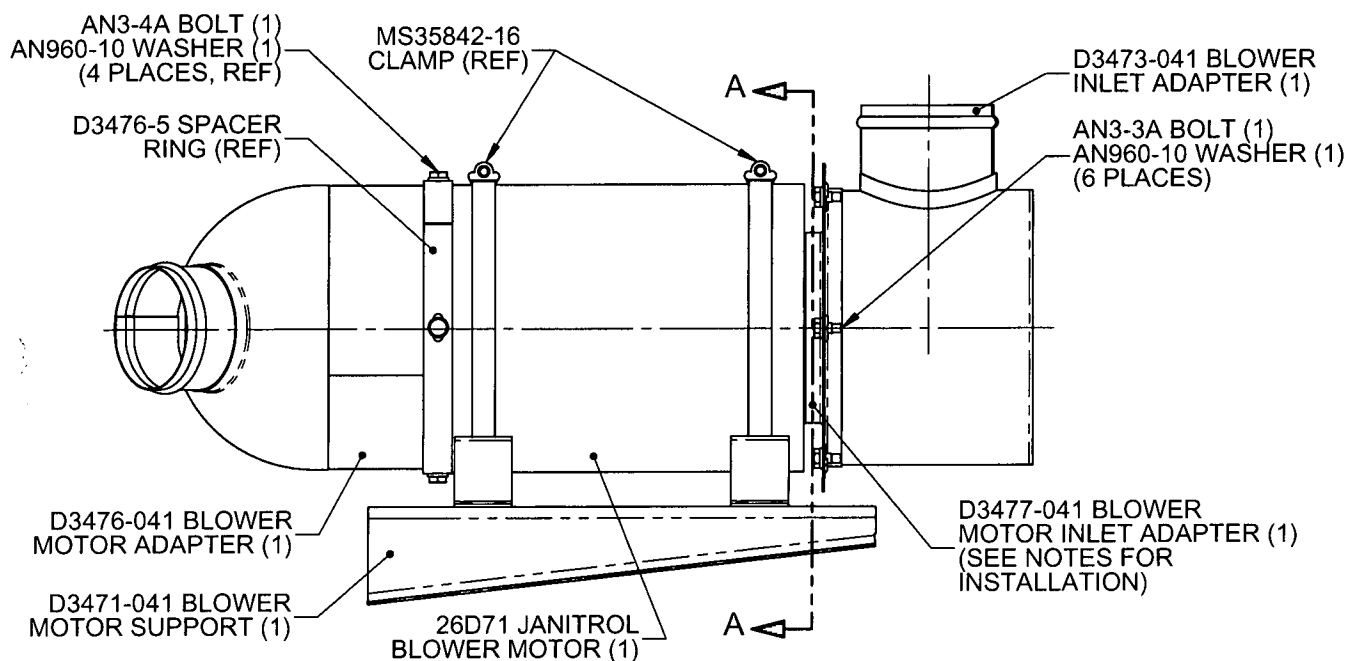
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APPROVED	
BY:	<i>D. Shepherd</i> D. SHEPHERD (DE # 02)
DATE:	07.01.02
CERT. NO.:	SH05-45
ISSUE NO.:	1

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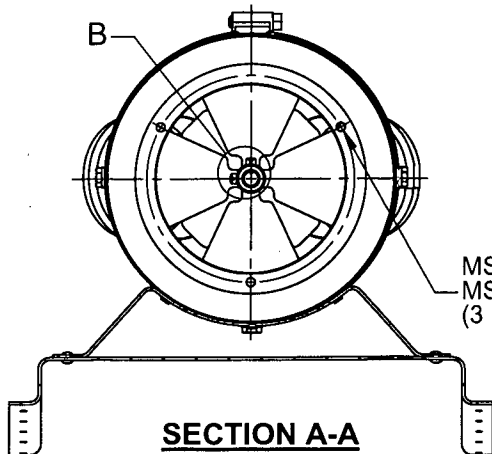
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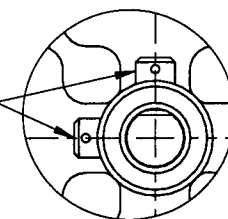
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CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9341	REV. B SHEET 2 OF 2
DATE 07.01.02		TITLE BLOWER MOTOR ASSEMBLY	SCALE 1:4



D206-746-043 BLOWER MOTOR ASSEMBLY



REPLACE EXISTING SET SCREWS
WITH D3585-1 SET SCREWS (2),
APPLY LOCTITE 226, TORQUE TO
50-70 in-lbs (5.6-7.9 N-m) AND SECURE
USING MS20995-025E LOCK WIRE



DETAIL B
SCALE 1:1

MS27039-08-04 MACHINE SCREW (1)
MS35333-38 LOCK WASHER (1)
(3 PLACES)

SECTION A-A

NOTES:

- 1) ON 26D71 BLOWER MOTOR, REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1).
- 2) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 3) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED.

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 07.01.02
CERT. NO.: SH05-45
ISSUE NO.: 1

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